

Date: Friday, 18/07/2008 2:14:55 PM
User: Julie Lecocq

Process Sheet

slp 28/07

Customer : CU-DAR001 Dart Helicopters Services Job Number : 40668 Estimate Number : 11248 P.O. Number : This Issue : 18/07/2008 S.O. No. : Prsht Rev. : NC First Issue : / / Type : LARGE FAB ASSY Previous Run : 39868 Written By : Checked & Approved By : <u>JUL 08.7.18</u> Comment : Est A05.05.18 New Issue KJ/JLM	Drawing Name : STEP WELDMENT ASSEMBLY Part Number : D3438042 Drawing Number : D3438 REV A Project Number : N/A Drawing Revision : A Material : Due Date : 25/07/2008 Qty: 2 Um: Each
---	---

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D2244116	Step Extrusion
-----	----------	----------------



✓
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Step Extrusion
 Batch B 38023 SAD 08/07/21 (2)

2.0	D267334	End Plate
-----	---------	-----------



✓
Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Pick:

Qty	Part No.	Description	Batch
2	D2673-34	End Cap	<u>B 35887</u> <u>08-07-21</u> <u>SA</u>

3.0	D2561	Lug
-----	-------	-----



✓
Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Pick:

Qty	Part No.	Description	Batch
2	D2561	Lug Plate	<u>B 37153</u> <u>08-07-21</u> <u>SA</u>

4.0	D2564	Mounting Angle
-----	-------	----------------



✓
Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Pick:

Qty	Part No.	Description	Batch
2	D2564	Mounting Angle	<u>B 38026</u> <u>08-07-21</u> <u>SA</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 18/07/2008 2:14:55 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT ASSEMBLY

Job Number: 40668

Part Number: D3438042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244 to 79.63" at 34° as per Dwg D3438

2-Deburr ends

3-Weld one cap, LUG PLATES & MOUNTING ANGLE as per Dwg D3438 using DT8343

4-Grind

SAD 08/07/21 (2)
SP 08-07-22
SAD 08/07/21 (2)

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SOB 4/23/22

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAD 07/07/23 (2)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M. 08/07/23 (2x)

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld last cap per dwg D3438 & grind flush

SP 08-07-23 (2x)

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

SP 08-07-23 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 18/07/2008 2:14:55 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT ASSEMBLY

Job Number: 40668

Part Number: D3438042

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/03 (22)

13.0

POWDER COATING

POWDER COATING



M 108523



(2X)

Comment: POWDER COATING

1-Touch up alodine

2-Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:10
320 OF
8:40

M: 08/07/24

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg 3438 and QSI 005 4.4

Mask off 0.5 each side of D2561 lugs

M 108496

bf 08-07-24 (2)

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

bf 08/07/24 (2)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPP Bps 620 Res/ps (2)

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/25

Job Completion



mf 08-07-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

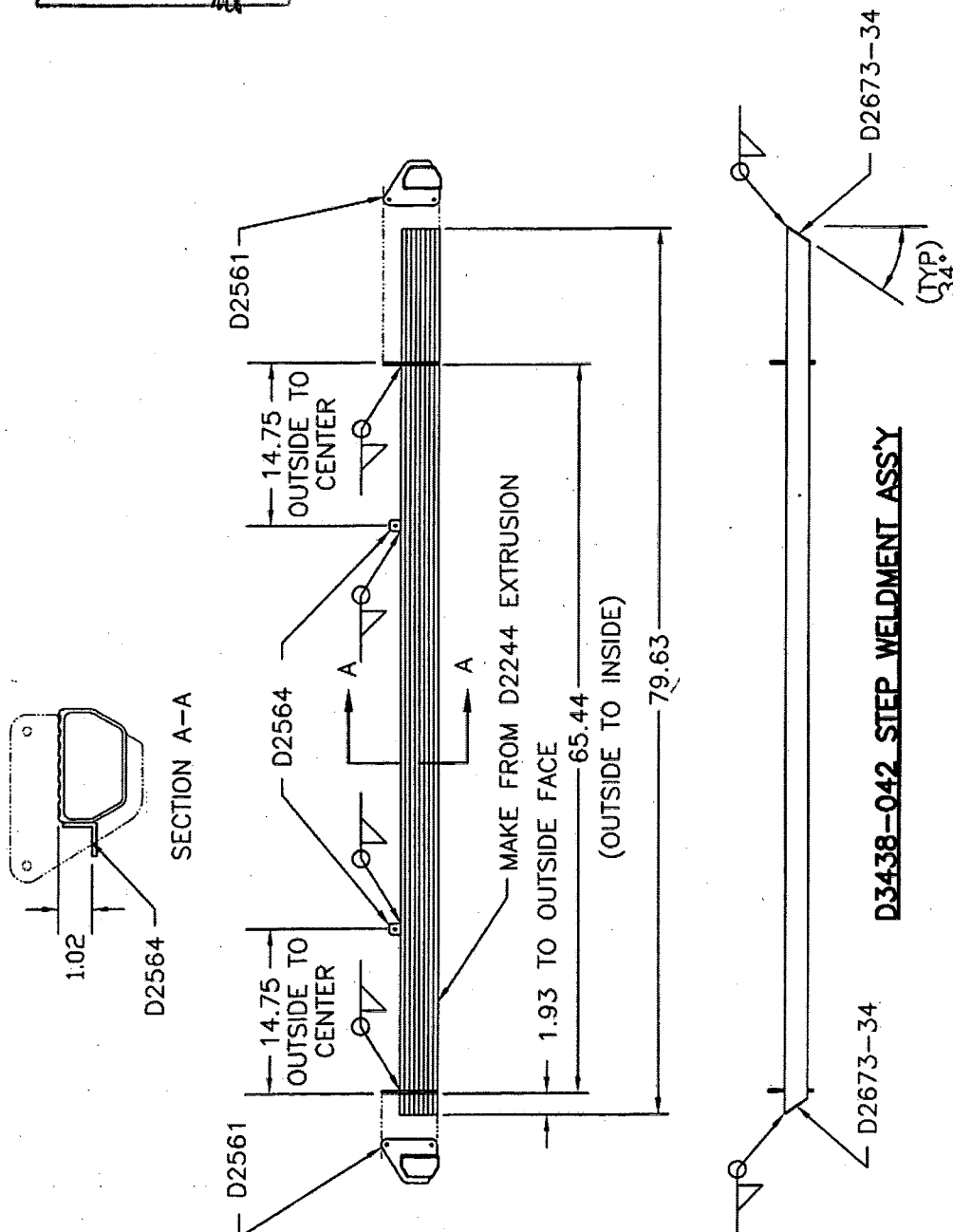
NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3438	REV. A SHEET 1 OF 1
DATE 05.05.09		TITLE STEP WELDMENT ASSEMBLY	SCALE 1:1
A	05.05.09	NEW ISSUE	

RELEASED

05-05-27

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) TOLERANCES ARE PER DART QSI 018
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) FINISH: ACID ETCH & ALODINE PER QSI 005 4.1, POWDER COAT WHITE PER QSI 005 4.3.5.1 WING WALK TOP PER QSI 005 4.4, MASK OFF 0.5 EACH SIDE OF D2561 LUGS

SHOP COPY
RETURN TO
ENGINEERING

Copyright © 2005 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

UNCONTROLLED COPY**SUBMITTED AMENDMENT****WITHOUT NOTICE****WORK ORDER**

NO. 40008

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries